

Work Order ID 92070

October-22-12 3:18:02 PM

92070

Page 1

Item ID: 647.1810

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Nose Door Doubler

Stop ***NS2***

Start Date: 22/10/2012 ~ Start Qty: 6.00

6

Cust Item ID:

Required Date: 05/11/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLS Date: 12-10-22 Tooling: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.1800	N/C								
110		0.00							
110									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
	Dwg Rev: <u>N/C</u>								
	Prog Rev: <u>N/C</u>								
	2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

6 8 Jm 12-11-1

6 0 Jm 12-11-1

Work Order ID 92070

October-22-12 3:18:02 PM

92070

Page 2

Item ID: 647.1810

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Nose Door Doubler

Start Date: 22/10/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 05/11/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				6			
140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo ISSUE P/O: 18304 HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	0.00 0.00							12-10-01
150 *150* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.00							12/11/12 (6)

92070

Page 3

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 22/10/2012 **Start Qty:** 6.00 ***6***

Required Date: 05/11/2012 **Req'd Qty:** 6.00 ***6***

Customer:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

Work Order ID 92070

October-22-12 3:18:02 PM

92070

Page 4

Item ID: 647.1810

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Nose Door Doubler

Stop ***NS2***

Start Date: 22/10/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 05/11/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

12/11/2012 (6)12/11/2012
MF
12-11-24

Picklist Print

October-22-12 3:18:07 PM

Page 1

Work Order ID: 92070

92070

Parent Item: 647.1810

647 1810

Parent Item Name: Nose Door Doubler

Start Date: 22/10/2012

Required Date: 05/11/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	40.4700	0.153	0.9663 16			

M2024T3S 063

**

1.0

Jim 12-11-12

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

40.47

119916

0.1

121197

16.32

123096

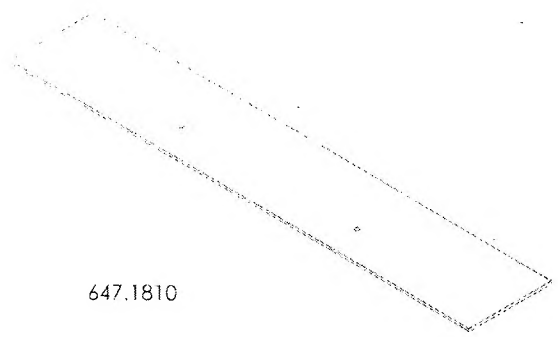
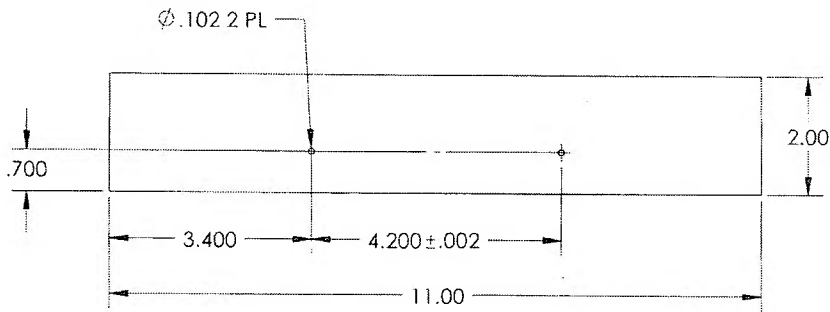
24.05

123096

DATE	REV	BY	APP
10/10/92	1	W	
10/10/92	2	W	
10/10/92	3	W	
10/10/92	4	W	
10/10/92	5	W	
10/10/92	6	W	

NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



647.1810

SEVEN
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 92070 ML5
12-10-22

.063

		647.1818	NOSE DOOR SPACER	△	△
		647.1817	SUPPORT, RH	△	△
		647.1816	SUPPORT, LH	△	△
		647.1815	GUSSET, RH	△	△
		647.1814	GUSSET, LH	△	△
		647.1813	ANGLE	△	△
		647.1812	SHIM	△	△
		647.1811	SPACER	△	△
		647.1810	NOSE DOOR DOUBLER	△	△
	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY	PARTS LIST				
NEXT ASSY (S)	APICAL INDUSTRIES				
647.1800	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300				
	SHEETMETAL				
	WHERE DIMENSIONS SPECIFIED DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED FRACTIONS SHALL BE IN 16THS DECIMALS SHALL BE TO 3 PLACES ANGLES SHALL BE TO 1/2°				
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ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
 ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED
 THE USE OF DIMENSIONS ON THIS DRAWING IS FOR INFORMATION ONLY

.25 X 45.0°
 4 PL

1.00

3.63

.063

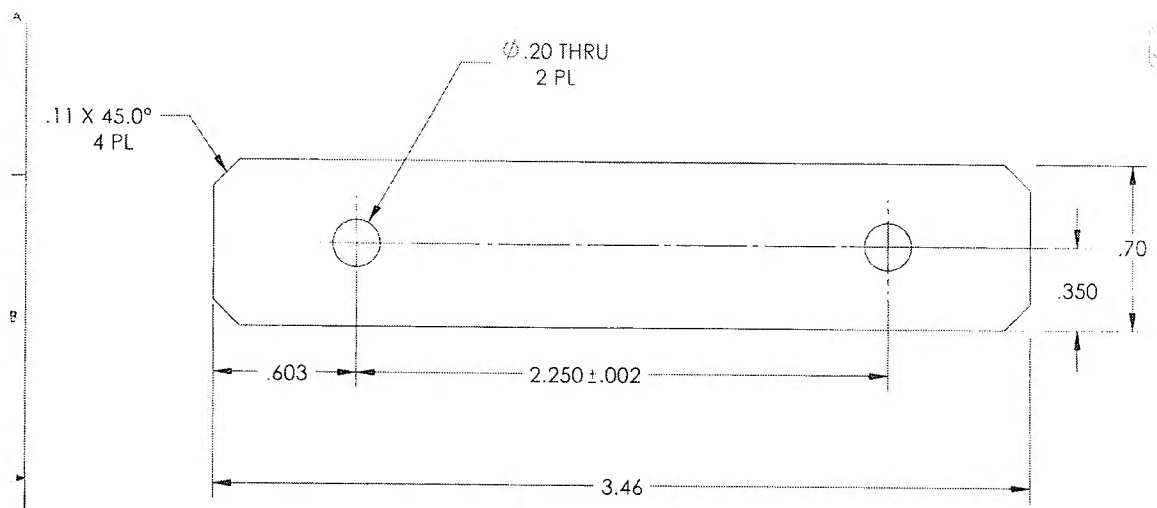
92070

647.1811

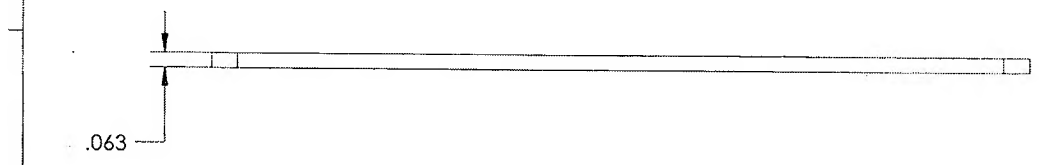
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DESIGNED BY	CHIEF		
CHECKED BY	P. MALVO		
DATE			
DRAWING APPROVAL		SHEETMETAL	
BY			
DATE			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED		SIZE	REV.
DIMENSIONS ARE IN INCHES		B 07/01/68	647.1800
TOLERANCES ARE		SCALE: NONE	1/2" = 1"
SPACING DIMENSIONS ARE		SHEET 2 OF 7	
HOLE SIZE			

ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE IN INCHES
 ALL DIMENSIONS ARE TO BE HOLE CENTER UNLESS OTHERWISE SPECIFIED
 ALL DIMENSIONS ARE TO BE HOLE CENTER UNLESS OTHERWISE SPECIFIED

92070



647.1812

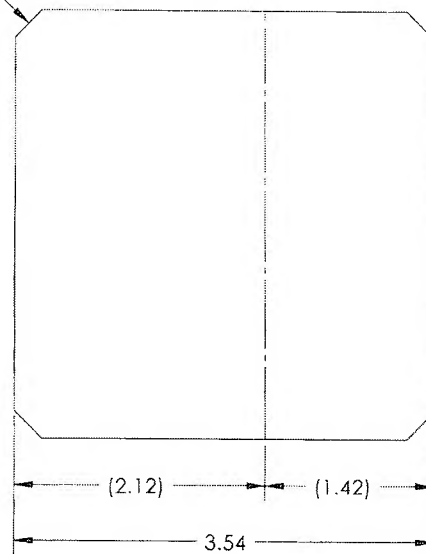


DATE: 01/10/08 DRAWN BY: C. BROWN CHECKED BY: P. BROWN DESIGNED BY: P. BROWN MANUFACTURED BY: C. BROWN		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
SHEETMETAL		REV: 07/02/06 Dwg No: 647.1800 REV: N/C	
SCALE: NONE		SHEET 3 OF 7	

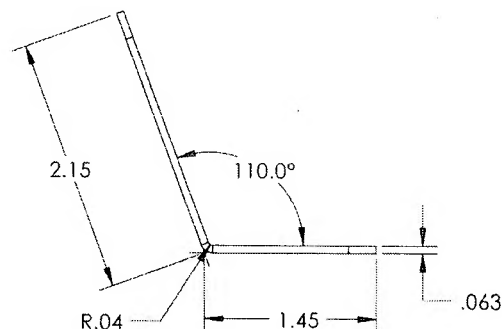
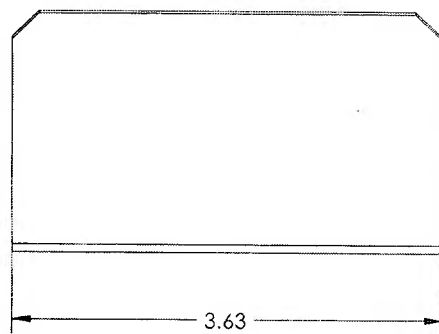
ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE IN INCHES.
 APICAL INDUSTRIES AND HERBY INDUSTRIES ARE NOT RESPONSIBLE FOR ANY
 ERRORS OR OMISSIONS OR FOR ANY CONSEQUENCES OF ANY SUCH ERRORS OR OMISSIONS.

92070

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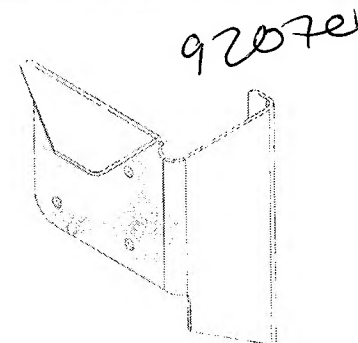


FLAT PATTERN



647.1813

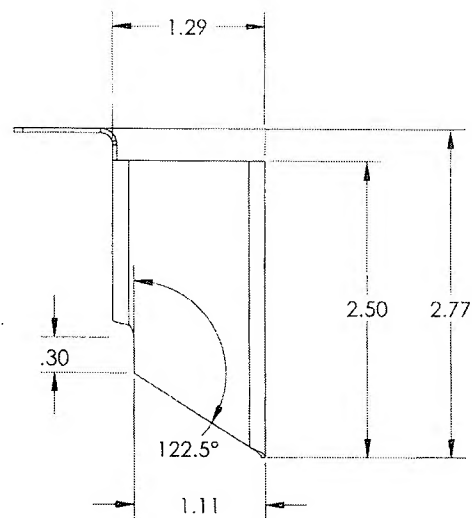
ORIGINAL DATE 02-04-15	DESIGNER P. BRAND	APICAL INDUSTRIES 2408 TEMPLE HEIGHTS DR OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY P. BRAND	CHECKED P. BRAND		
TOLERANCE APPROVAL P. BRAND	BY BRAND		
CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ALL DIMENSIONS ARE TO CENTER	REV	CASH CODE	REV
	B	07M16	647.1800
	SCALE: NONE		SHEET 4 OF 7



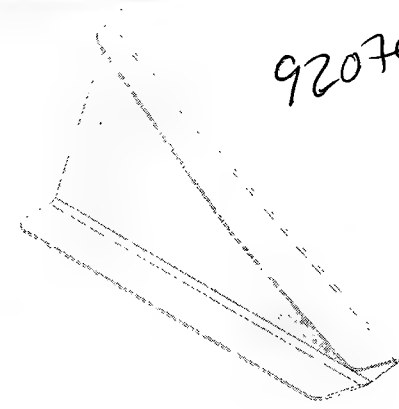
Technical drawing of a mechanical part, likely a bracket or support, showing dimensions and tolerances.

Key dimensions and tolerances:

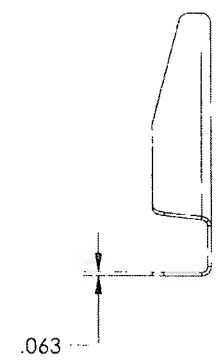
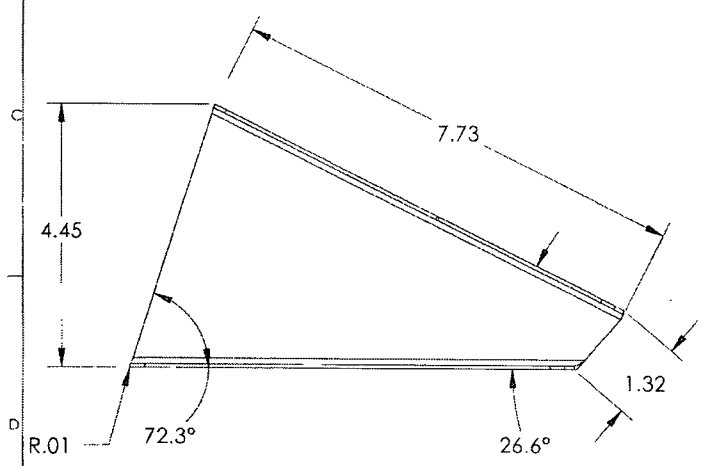
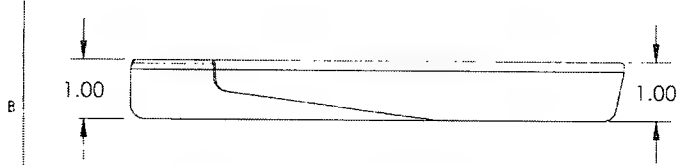
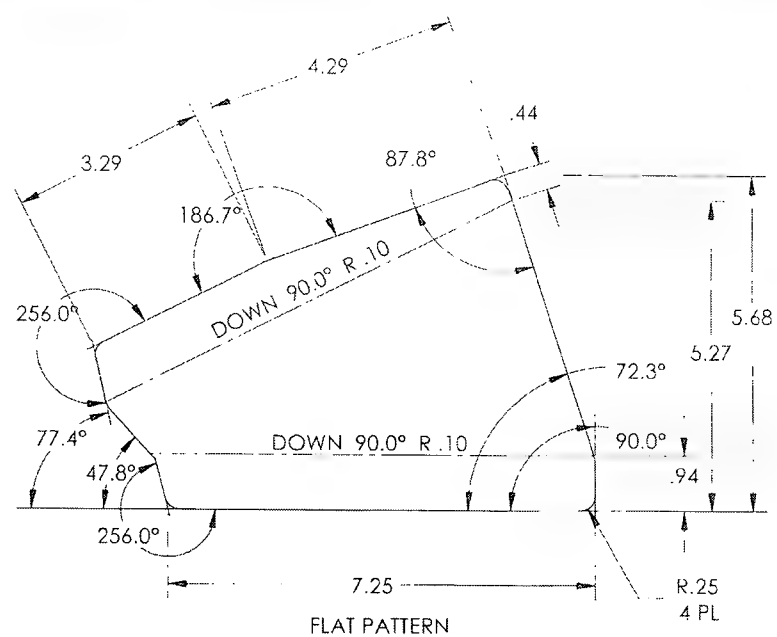
- Overall width: 1.70
- Overall height: 1.62
- Top horizontal section width: .27
- Bottom horizontal section width: .260
- Overall length: 8.70 ± .002
- Hole specification: Ø.100 4 PL
- Fillet radius: R.07
- Tolerances: ±.002 for length and height, .002 for the height of the top section.

[illegible]

92070



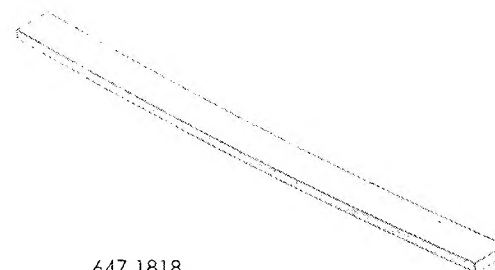
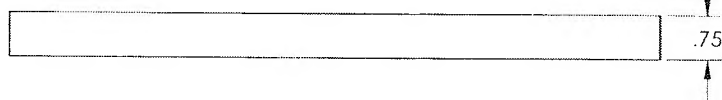
647.1816 SHOWN
647.1817 OPPOSITE



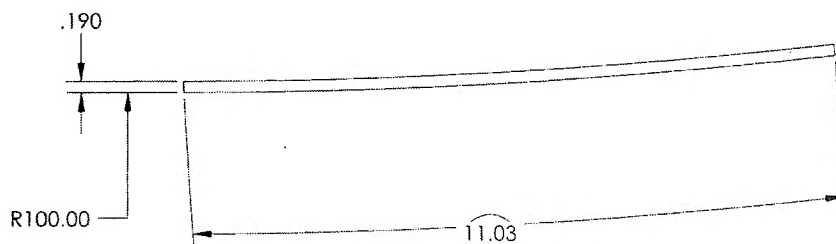
PROJECT SITE PROJECT NO. DRAWN BY CHECKED DATE SCALE SHEET		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. GCEANSIDE, CA. 92056-3512 (760)724-5300 SHEETMETAL SCALE: NONE SHEET 6 OF 7	
VENDOR/IMPORTER/USER ORDER NO. ORDER DATE ORDER QTY ORDER UNIT		B 07/10/20 647.1800	IN/C

ALL DIMENSIONS ARE TO BE SHOWN IN THIS DRAWING. THE QUALITY OF THE MATERIAL IS THE RESPONSIBILITY OF THE FABRICATOR. THE FABRICATOR SHALL BE RESPONSIBLE FOR THE QUALITY OF THE MATERIAL.

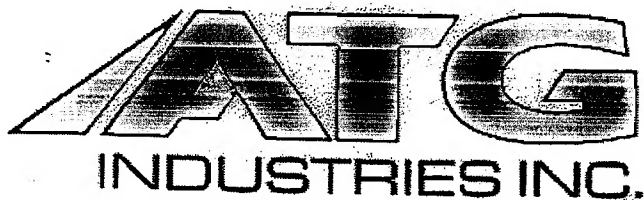
92070



647.1818



DATE: 07/12/20 DRAWN BY: P. BAYO CHECKED BY: P. BAYO DESIGNED BY: P. BAYO SCALE: NONE		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300	
SHEET METAL SHEET 7 OF 7		SHEET 7 OF 7	
DATE: 07/12/20 DRAWN BY: P. BAYO CHECKED BY: P. BAYO DESIGNED BY: P. BAYO SCALE: NONE	DATE: 07/12/20 DRAWN BY: P. BAYO CHECKED BY: P. BAYO DESIGNED BY: P. BAYO SCALE: NONE	DATE: 07/12/20 DRAWN BY: P. BAYO CHECKED BY: P. BAYO DESIGNED BY: P. BAYO SCALE: NONE	DATE: 07/12/20 DRAWN BY: P. BAYO CHECKED BY: P. BAYO DESIGNED BY: P. BAYO SCALE: NONE



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 10 PCS 646.9813 10 PCS 646.9811 10 PCS 646.9812 10 PCS 646.9812 2 PCS 646.9811 15 PCS 646.4711 15 PCS 647.4716 15 PCS 647.4712 15 PCS 647.4717 15 PCS 647.4714 15 PCS 647.4715 15 PCS 647.4718 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120674	Rev:	
		PO: PO18153	Line: 101214/7
1 lot	Part: ASST 7 PCS 647.1810 14 PCS 647.1811 91 PCS 647.1812 2 PCS 647.1612 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120673	Rev:	
		PO: PO18304	Line:
Certificate of Conformance			



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms

Ship Via

Quantity

Description

A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.

ISO 9001 : 2008 REGISTERED
ATG SALES-2010 TERMS APPLY

DATE: 5/12/12

CERTIFIED SIGNATURE: 

RECEIVER SIGNATURE: _____